Each

Dart Aerospace Ltd. Tuesday, 10/2/2007 1:20:21 PM Kim Johnston **Process Sheet Drawing Name** : BUSHING : CU-DAR001 Dart Helicopters Services Customer Job Number : 34948 : 10725 **Estimate Number** : NA : D2652 Part Number P.O. Number D2652 REV A : 10/2/2007 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS **Drawing Revision** First Issue : 34893 Material Previous Run : 10/30/2007 **Due Date** 200 Um: Written By Checked & Approved By : Est Rev: 02.06.13 Now machined in house. NG Comment Additional Product Job Number: Machine Or Operation: Description: Seq. #: 303 Round Bar 0.500" M303R0500 Comment: Qty.: 0.0578 f(s)/Unit Total: 11.5500 f(s) Material:303 ss .500" Round Bar (M303R0500) Batch:_M 105 839 2.0 HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA250. & Dwg D2652 2-Deburr QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 SECOND CHECK

5.0

Comment: SECOND CHECK PACKAGING 1

Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:_

Pe 1/1/12 (2

Dart Aerospace Ltd

W/O:		WORK ORDER C	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: <u>07/10/10</u>
			QA: N/C CI	osed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC Corrective Action Section B			Verification	Annewal	Ammayal			
DATE	STEP	Section A Initial A Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date:

Tuesday, 10/2/2007 1:20:21 PM

Üser:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34948

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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Dart Aerospace Ltd

W/O:		WORK ORDER (WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	·	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	···			
			QA:	N/C Close	d:	Date:				

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E	}	Verification	Approval Chief Eng	l
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34948
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010					
0.060	+/-0.005					
Ø0.305	-0.002/+0.000					
Ø0.191	+0.005/-0.000					
Ø0.500	+/-0.010					
0.030 x 20°	+/-0.010					
R0.010	+0.010/-0.000					
					4	

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	· 7

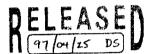
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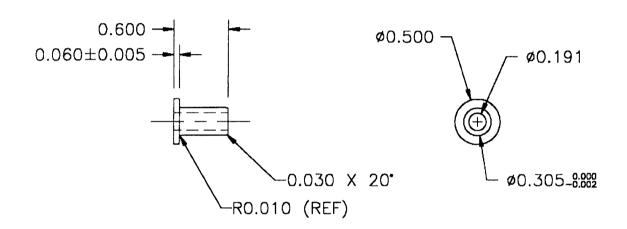
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DESIGN	DRAWN BY	DART AEROSPACE FAIRCHILD INTERNATIONAL	•
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	101 BY	D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

DART AEROSPACE LTD	Work Order:	34348
Description: Bushing	TYOIR Older.	24248
Description. Busining	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

r		X First Arti	icle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
0.600	+/-0.010	0.602				
0.060	+/-0.005	0.060	V	-		
Ø0.305	-0.002/+0.000	0.3045	7			
Ø0.191	+0.005/-0.000	0,1935				
Ø0.500	+/-0.010	1 498K	V			
0.030 x 20°	+/-0.010	0.4985 .03×28				
R0.010	+0.010/-0.000	0.015				
		0.613				
						
						

ı	Measured by:	A		
		1	Prototype Approval:	N/A
Ĺ	Date: 07/10/10	Date: 07/10/10	Date:	

Rev Date	Change		
A 03.12.12	New Issue	Revised by	Approved
		KJ/RF	. 4